

Work Order ID 143778

March 22, 2016 1:40:47 PM

143778

Page 1

Item ID: D3773-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Adapter
 Start Date: 3/23/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/5/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: SIA Date: 20160322 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3773	Rev B								

100. BAND SAW 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blank 2.700" long

10 10 16-3-26

110 HAAS CNC VERTICAL MACHINING #1 0.01
110
 HAAS 1 Memo 0.10
 HAAS CNC vertical machine #1 1- Mill as per Folio FA740 Rev: AA & Dwg D3773 Rev: B 2-Deburr per dwg D3773

10 1 16/03/29

DAS 14 9-39 PTO

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00
 Quality Control

10 10 16/03/29

DAS 14 9-39

DQA:

Date: 16.05/10



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/05/10

Work Order update only ☐

Work Order: <u>143778</u> Part No. <u>D.3773-1</u> NCR No. <u>16-5774</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16/03/30</u>	Step #: <u>110</u>	QTY Effective: <u>1</u>		MRB (QSI042) Approval																																																																	
Description Work Order Deviation		Disposition		<u>16-03-30</u> DAS Completed By 14 9-09 <u>16/03/30</u>																																																																	
1 part scrap. drill and broke inside the part.		scrap and destroy replace Qty Batch # M130030		Lead hand / Supervisor DAS Approval Verification 14 9-09 <u>16/03/30</u>																																																																	
				QC / QA Coordinator Approved MAR 30 2016 DAS 38																																																																	
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March 22, 2016 1:40:47 PM

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Page 2

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Revision ID: Stop ***NS2***
Item Name: Adapter
Start Date: 3/23/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/5/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	LOCATION WA002								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.02							
Quality Control									

MLJ MAR 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

March 22, 2016 1:40:51 PM

Page 1
/1

Work Order ID: 143778

143778

Parent Item: D3773-1

D3773-1

Parent Item Name: Adapter

Start Date: 3/23/2016

Required Date: 4/5/2016

Start Qty: 10.00

Required Qty: 10.00

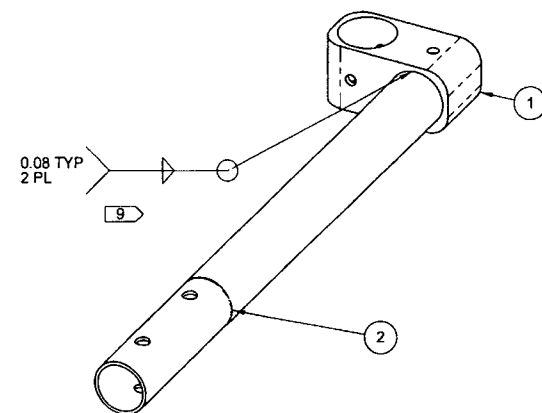
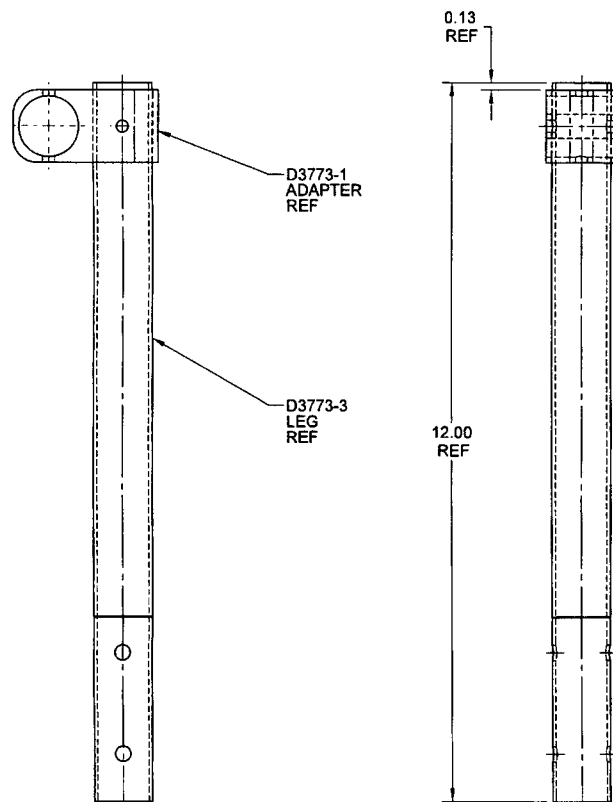
Comments: IPP Rev:A New Issue 08-05-07 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	10.5730	0.225	2.368421			
M304B1 500X1 500									**	<u>SL16-3-26</u>			
304 bar 1.50 X1.50													

SL16-3-26

Location	Loc Qty	Loc Code
MAT009	10.573	
M130031	10.573	

2.3
+ .225



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

20160322

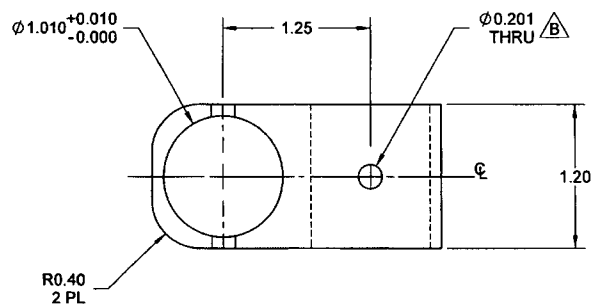
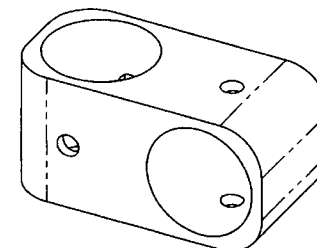
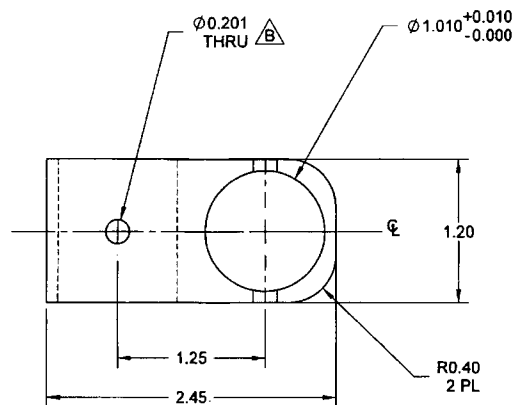
SA
143778

RELEASED
08-01-2014

- NOTES:
- 1) MATERIAL: SEE D3773-1/-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
 - 8) WELD: PER DART QSI 004
 - 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	SA	DRAWING NO.	REV. B
MFG. APPR.	SA	D3773	SHEET 1 OF 3
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	HEADREST ADAPTER	NTS
DATE	08.06.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

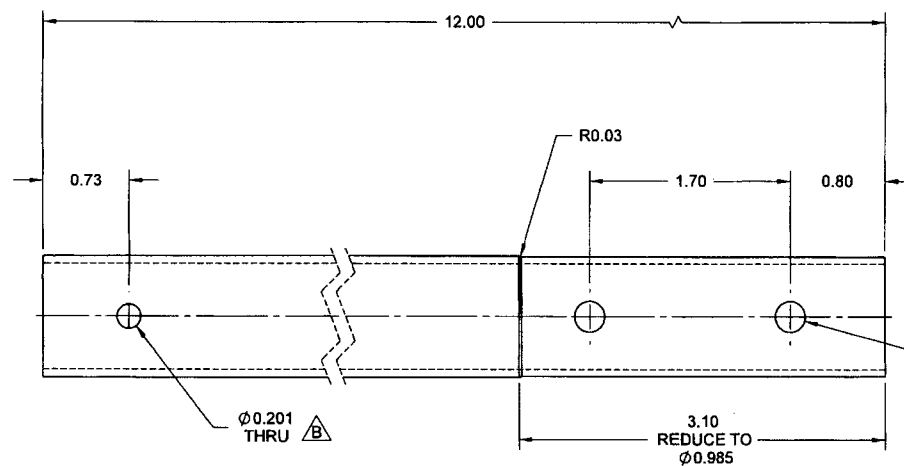


D3773-1 ADAPTER

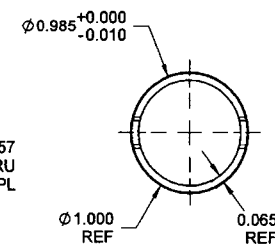
NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
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D3773-3 LEG



- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

RELEASED
08-07-10 MIA

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3773	REV. B
MFG. APPR.		TITLE HEADREST ADAPTER	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.06.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

